

Work Order ID 162404

Tuesday, June 06, 2017 4:57:32 PM

162404

U/R

OKAY TO
SHIP *MP*
6/13/2017
Page 1

Item ID: D117-762-011 Accept *N900040100* Setup Start *NS1*
Revision ID: URF 17-547 Stop *NS2*
Item Name: Skidtube with Standard Wearplates Fits LH or RH
Start Date: 6/12/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/23/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: JUN 12 2017 Tooling: Date: Run Start *NR1*
QC: **DAS 21 9-89** Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9771	A
IIN-D117-762	E

DA 6 9-8 JUN 13 2017

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 1.50
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D117-762-011 CHG004

DAS 27 9-89 **DAS 27 9-89**
JUN 13 2017

110 Pick Kit 0.00
110
Packaging Memo 0.00
Packaging

DAS 28 9-89 JUN 13 2017

B157974

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 162404***162404***

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Item ID: D117-762-011 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 6/12/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/23/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-762-011 Location :FG081								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89

JUN 13 2017

DAS
27
9-89

JUN 14 2017

DAS
21
9-89

JUN 14 2017



JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 162404

162404

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 6/12/2017

Required Date: 6/23/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.06.11New Issue EC
IPP Rev:B 08-02-22 change to revA DD verified by:ec
IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD
IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP
REV:E 15.06.11 IIN REV.D DD VERF:JLM IPP REV:F
17.01.17 PER CHG004 (dsi9771) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6C52A *AN6C52A* BOLT		Purchased	No			110	Each	27.0000	2	2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST333			27					
					m134535			3		2			
					m137490			24					
D5300-1 *D5300-1* GHL Bushing		Manufactured	No			110	Each	5.0000	2	2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST162			5					
					161352			5		2			
D5301-1 *D5301-1* GHL Plug		Manufactured	No			110	Each	2.0000	2	2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST162			2					
					161353			2		2			
D117-762-041 *D117-762-041* Replacement Skidtube		Manufactured	No			110	Each	0.0000	1	1			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST162			2					
					161353			2		2			

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Shop Packet Print

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Picklist Print

Monday, June 05, 2017 4:53:47 PM

Page 1/1

Work Order ID: 162404

162404

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 6/12/2017

Required Date: 6/23/2017

Start Qty: 1.00

Required Qty: 1.00

D3512-041 Manufactured No

110 Each 12.0000 2 2

D3512-041

Wearplate

**

DAS 28 JUN 13 2017

Location

Loc Qty

Loc Code

ST610

12

155744

4

161911

8

2

MS21043-6 Purchased No

110 Each 100.0000 2 2

MS21043-6

NUT

**

DAS 28 JUN 13 2017

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

36

m135470

2

m137361

34

ST302

44

m137479

44

2

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-762 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-762 REV. 4

REF FAA STC: SR01853SE

REF: TC LETTER OF ACCEPTANCE RDIMS-4374899

REF EASA STC: EASA.10017063

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to replace the ground handling lugs (D3864-1 Bushings, AN6C51A Bolts and MS21043-6 Nuts) on the D117-762-XXX Skidtubes with a structurally superior lug design (D5300-1 Bushings, D5301-1 Plugs, AN6C52A Bolts, MS21043-6 Nuts) as shown in Figure 1. The new hardware will be included in D117-762-011 @ CHG 004 and subsequent.

2.0 INSTALLATION

For D117-762-011 @ CHG 004 and subsequent, the ground handling hardware should be installed as follows:

- 2.1 Loosely install (qty 2) D5300-1 GHL Bushing & (qty 2) D5301-1 GHL Plug wet with Proseal 890 or MIL-S-8802 Class B2 Sealant in location shown in Figure 1.
- 2.2 Install (qty 2) AN6C52A Bolts and (qty 2) MS21043-6 Nuts in accordance with Figure 1. Clean up squeezed out Proseal and apply fillet seal around D5300-1 & D5301-1.
- 2.3 Torque AN6C52A Bolts 160 - 190 in-lbs (18.1 - 21.5 N-m).

3.0 PARTS LIST

For D117-762-011 @ CHG 004 and subsequent, the Part List in IIN-D117-762 and ICA-D117-762 is modified as follows:

IS

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	D117-762-011	SKIDTUBE INSTALLATION
50	2	AN6C52A	BOLT
51A	2	D5300-1	GHL BUSHING
51B	2	D5301-1	GHL PLUG
52	2	MS21043-6	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162407 MVS

1706-12

A	NEW ISSUE	RF	17.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9771	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.		GHL UPGRADE KIT	NTS
DATE	17.01.09	COPYRIGHT ©2017 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.	

WAS

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	D117-762-011	SKIDTUBE INSTALLATION
50	2	AN6C51A	BOLT
51	4	D3864-1	BUSHING
52	2	MS21043-6	NUT

4.0 WEIGHT AND BALANCE

There is negligible weight and balance change associated with this modification.

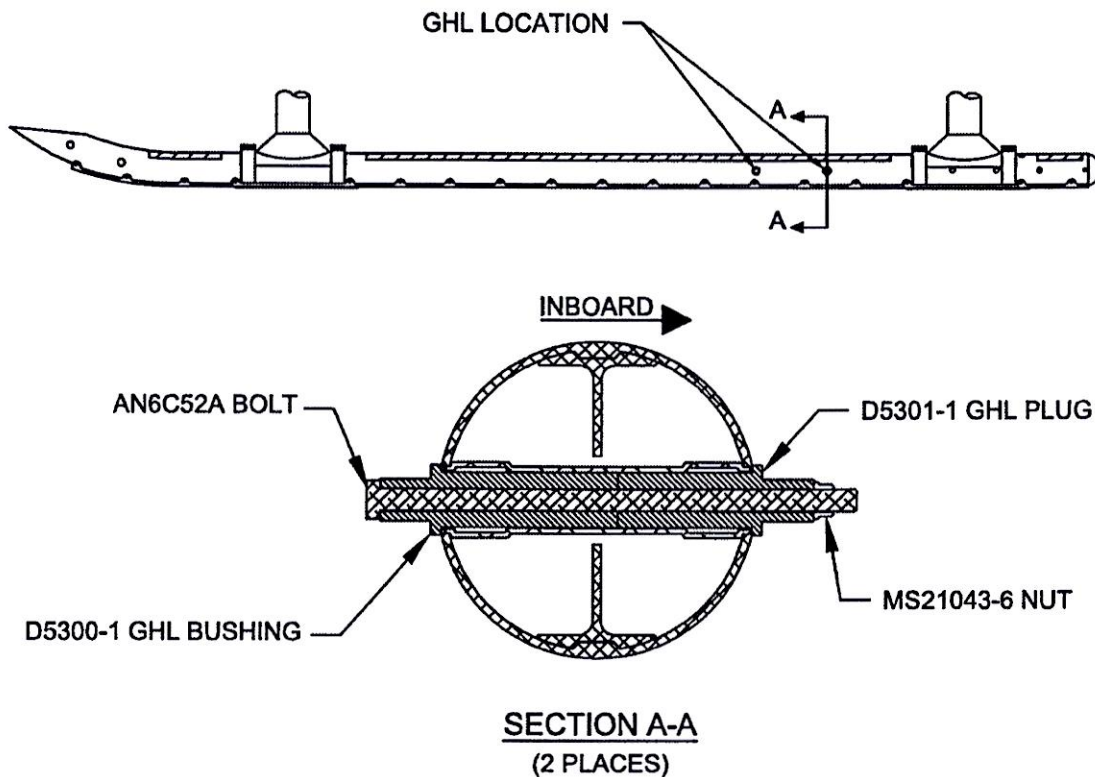


FIGURE 1 - GHL UPGRADE INSTALLATION

DESIGN	RF	DART AEROSPACE, LTD	
DRAWN	RF	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9771	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.		GHL UPGRADE KIT	NTS
DATE	17.01.09	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC	
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Work Order ID 162404

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6/11/2017
Page 1

Item ID: D117-762-011

Accept

N900040100

Setup Start *NS1*

Revision ID: URF 17-547

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Stop *NS2*

Start Date: 6/12/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/23/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

JUN 12 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI9771

A

IIN-D117-762

E

JUN 13 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

1.50

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D117-762-011 CHG004

CB

JUN 13 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

United States of America
Department of Transportation - Federal Aviation Administration

Supplemental Type Certificate

Number SR01853SE

This certificate, issued to

Dart Aerospace USA, Inc.
190 S. Danebo Ave.
Eugene, OR 97402

certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part 27 of the Federal Aviation Regulations.

Original Product—Type Certificate Number:

H13EU

Make:

Eurocopter Deutschland GMBH

Model:

MBB-BK 117 A-1; MBB-BK 117 A-3; MBB-BK 117 A-4;
MBB-BK 117 B-1; MBB-BK 117 B-2; MBB-BK 117 C-1;
MBB-BK 117 C-2

Description of the Type Design Change: Installation of skid tubes manufactured in accordance with Master Drawing List (MDL) MDL-D117-762, Revision D, dated July 2, 2013, or later Federal Aviation Administration (FAA) approved revision; installed in accordance with Installation Instructions IIN-D117-762, Revision B, dated January 24, 2013, or later FAA-approved revision; and maintained in accordance with Instructions for Continued Airworthiness (ICA) ICA-D117-762, Revision 1, dated February 13, 2013, or later FAA-accepted revision.

Limitations and Conditions: Approval of this change in type design applies only to the rotorcraft model listed above. This approval should not be extended to other rotorcraft of this model on which other previously approved modification are incorporated unless it is determined that the relationship between this change and any other previously approved modifications, including changes in type design, will introduce no adverse effect upon the airworthiness of that rotorcraft. A copy of this certificate, the MDL, installation instructions, and ICA must be maintained as part of the permanent record of the modified rotorcraft.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: November 22, 2007

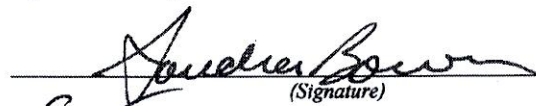
Date reissued: October 28, 2015

Date of issuance: June 26, 2008

Date amended: July 31, 2013



By direction of the Administrator


(Signature)
fo Manager, Seattle Aircraft Certification Office
(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.

This certificate may be transferred in accordance with FAR 21.47.